

Date: Wednesday, 30/07/2008 5:30:25 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT FACING SEAT ASS'Y LH		
Job Number	: 40822		Part Number	: D412769043		
Estimate Number	: 13306		Drawing Number	: D412-769-1 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 30/07/2008		Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 15/08/2008		
Previous Run	: 40821		Qty:	1 Um: Each		
Written By	:					
Checked & Approved By	: <u>JUL 08.7.31</u>					
Comment	: Est rev A 08.05.12 new issue DD verified by:EC					
	Est Rev:B 08-07-17 revB as per dwg DD verified by:ec					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1			
Pick Packing Kit			
2.0	D3782045	Back Leg Assembly	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)			
Back Leg Assembly			
batch: <u>B40873-3</u> FF 08/08/27			
3.0	D3782041	Front Inboard Leg Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)			
Front Inboard Leg Assembly			
batch: <u>B40870</u> SP			
4.0	D3782043	Front Outboard Leg Assembly, LH	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)			
Front Outboard Leg Assembly, LH			
batch: <u>B40871</u> SP			
5.0	D3783041	Lateral Brace Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)			
Lateral Brace Assembly			
batch: <u>B40874</u> SP			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40822

Part Number: D412769043

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 D37671 Upper Rail

AA



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch: B40864

14.0 D37921 Seat Belt Eye Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Seat Belt Eye Bolt

batch: B41521

SD

15.0 AN415A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M104746

SD

16.0 AN45 13A EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch: M109013

SD

17.0 AN510A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M108471

SD

18.0 AN513A Bolt



SD

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108167

8/8/22

SD

19.0 AN960JD10 Washer



SD

Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

batch: M109059

(or NAS1149D0363J) batch: M109059

FF 08/08/27

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40822

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
20.0	AN960JD416	Washer
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Washer batch: <u>M108161</u>	<u>SP</u>
21.0	AN960JD516	Washer
	Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s) Washer batch: <u>M108672</u>	<u>SP</u>
22.0	AN52510R24	Screw
	Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s) Screw batch: <u>M108276</u>	<u>SP</u>
23.0	MS21042L3	Nut
	Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s) Nut batch: <u>M108761</u>	<u>SP</u>
24.0	MS21042L4	Nut
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Nut batch: <u>M107499</u>	<u>SP</u>
25.0	MS21042L5	Nut
	Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s) Nut batch: <u>M108471</u>	<u>SP</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

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Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40822

Part Number: D412769043

Job Number:



Seq. #: Machine Or Operation:

Description :

26.0 SMALL FAB 1. SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-1

FF 08/08/27

(1)

27.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/08/27

28.0 POWDER COATING POWDER COATING



M106442

(X)

Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- Powder coat remainig of assembly grey as per dwg D412-769-1

(P2)

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:15

OVEN TEMPERATURE:

320°F

FINISH TIME:

10:45

M 08/08/28

29.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-28

(X)

30.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0 D37751 Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Guard

batch: B40869

FF 08/08/29

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		add AW960JP 516 M108672 Ar5-13A M108167 MS2(042LT M10847)					

Part No: D412-761043 PAR #: N/A Fault Category: Prod / Finishing NCR: Yes No DQA: D Date: 08/08/09
 QA: N/C Closed: D Date: 08/08/09

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/8/09	5 28	During inspection found a D3783-041 with a piece of masking tape that was power coated over top of.	<u>J</u> <u>Initial</u>	Remove piece of tape.	<u>M/J</u> <u>08/08/09</u> <u>Sub off</u>	<u>M/J</u> <u>08/08/09</u> <u>Sub off</u>	<u>J</u> <u>08/08/09</u>	<u>J</u> <u>08/08/09</u>
		R.C. tape was not removed before power coating.	<u>J</u> <u>Initial</u>	Scuff metal length of M/J D3783-041 with 320 grit.	<u>M/J</u> <u>08/08/09</u> <u>Sub off</u>	<u>M/J</u> <u>08/08/09</u> <u>Sub off</u>	<u>J</u> <u>08/08/09</u>	<u>J</u> <u>08/08/09</u>
				Sand paper.	<u>M/J</u> <u>08/08/09</u>	<u>M/J</u> <u>08/08/09</u>		<u>J</u> <u>08/08/09</u>
				Re powder coat as per QS2005	<u>M/J</u> <u>08/08/09</u>	<u>SJS</u> <u>08/08/09</u>		<u>J</u> <u>08/08/09</u>
				Re inspect QC #3.		<u>J</u> <u>08/08/09</u>		<u>J</u> <u>08/08/09</u>

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: AFT FACING SEAT ASS'Y LH
Job Number: 40822		Part Number: D412769043
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
32.0	D37741 	Seat Bottom, LH/RH 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Bottom, LH batch: B40867		SB
33.0	D37743 	Seat Back, LH/RH 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Bottom, LH batch: B40868		2B
34.0	AN525 10R22 	Screw 
Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Screw batch: B107936		SB
35.0	AN960JD10L 	Washer 
Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Washer batch: H105793 (or NAS1149D0332J) batch:		SB
36.0	MS21042L3 	Nut 
Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s) Nut batch: H108701		SB
37.0	AN35A 	Bolt 
Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Bolt batch: H100188		SB 08/08/29
38.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- install remaining parts as per dwg D412-769-1		FF 08/08/29

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT FACING SEAT ASS'Y LH

Job Number: 40822

Part Number: D412769043

Job Number:



Seq. #:	Machine Or Operation:	Description :
39.0	QC5	INSPECT WORK TO CURRENT STEP
		<i>Soledar 81</i>
40.0	PACKAGING 1	PACKAGING RESOURCE #1
		<i>AS 08/08/29</i>
41.0	QC21	FINAL INSPECTION/W/O RELEASE
		<i>AP 08/08/29</i>
		<i>MF 08-08-29</i>
		<i>Comment: FINAL INSPECTION/W/O RELEASE</i>

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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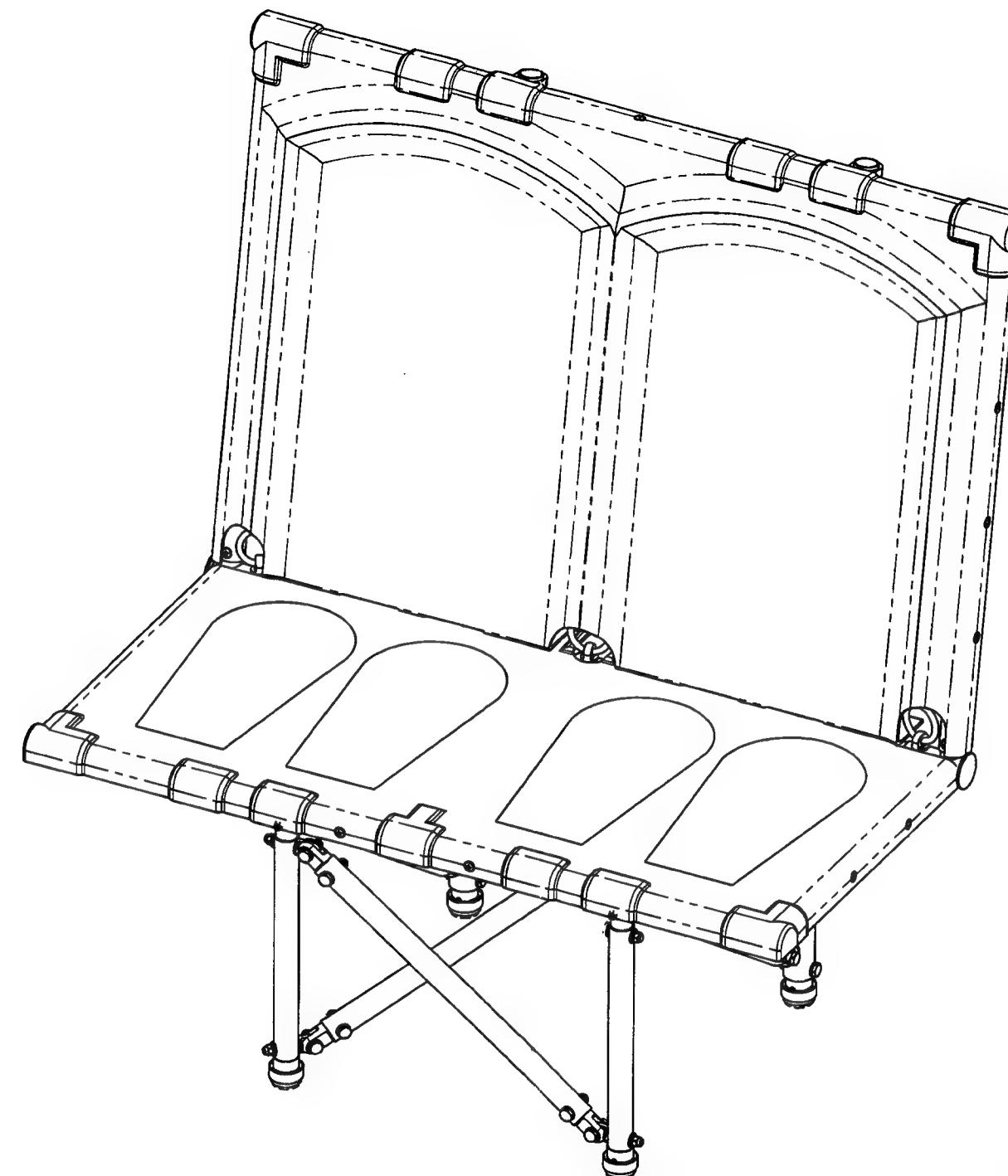
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D412-769-043 AFT FACING SEAT ASSY, LH

RELEASED
58-07-09 TWD

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40822

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	AA	D412-769-1	SHEET 1 OF 7
APPROVED	MP	TITLE	SCALE
DE APPR.	AA	AFT FACING SEAT ASSY, LH	NTS
DATE	08.06.25	COPRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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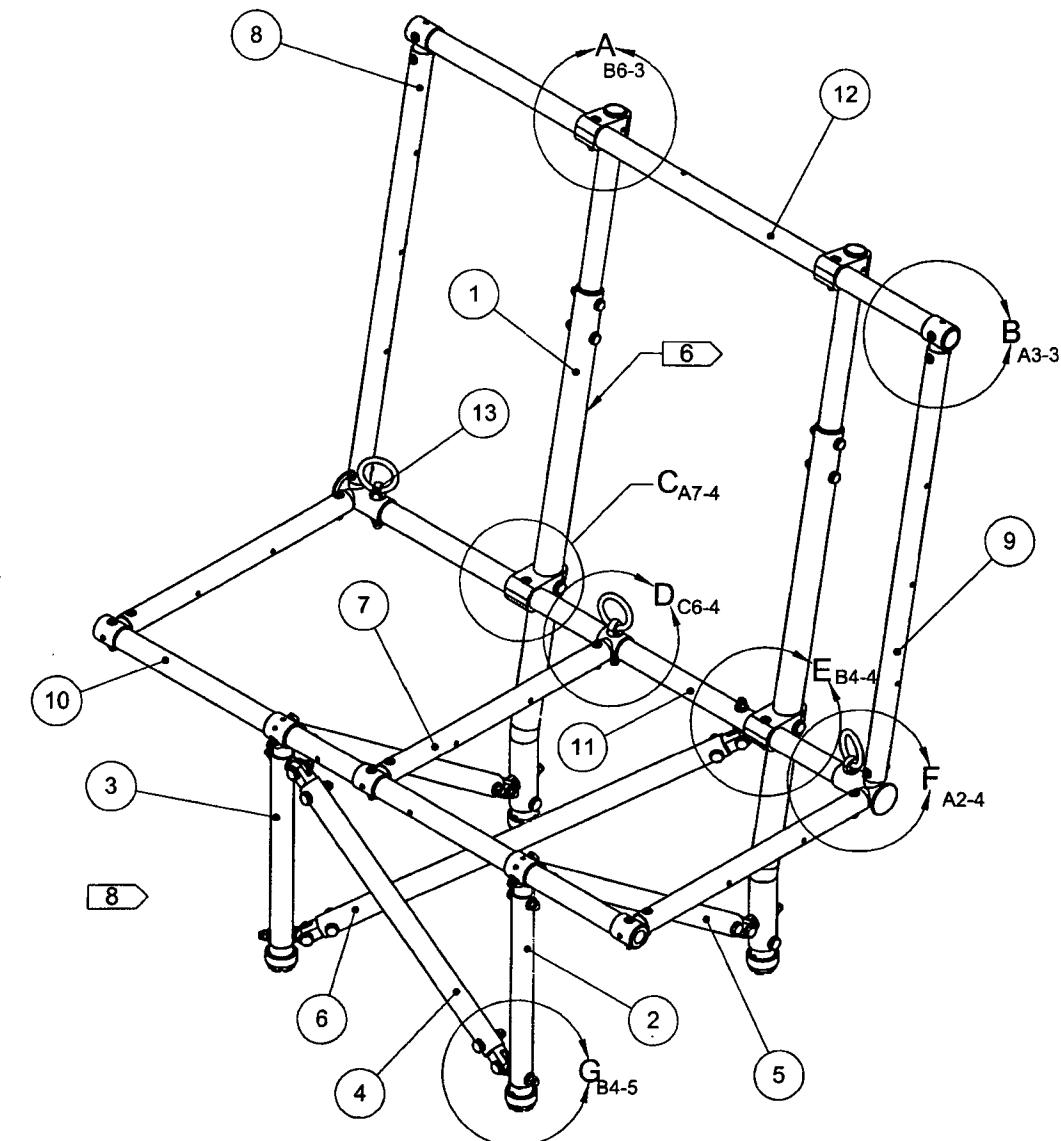
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-043	FRONT OUTBOARD LEG ASSY, LH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-1	FRONT RAIL, LH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20

B
B

D412-769-043 AFT FACING SEAT ASSY, LH

RELEASED
08.07.09

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WORK ORDER
NO. 00822

NOTES:

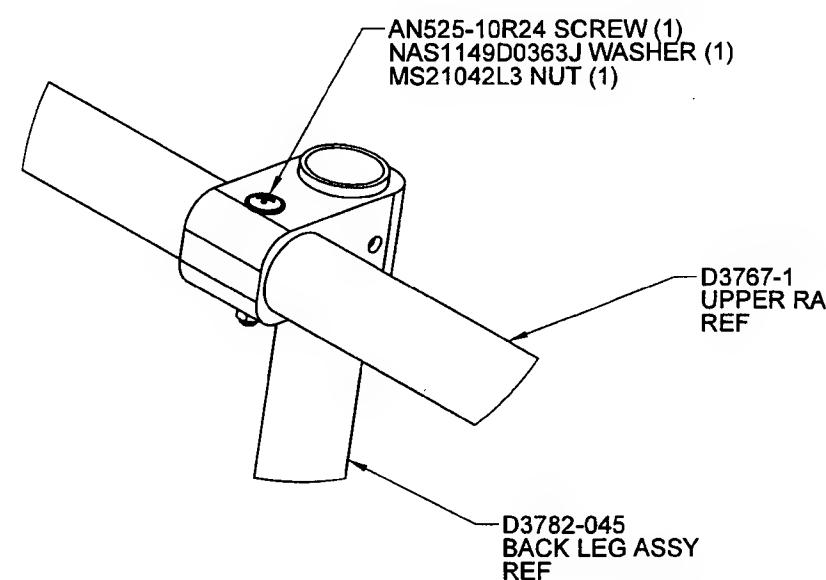
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLED SEAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1/-3). MASK FRONT LEGS PRIOR TO POWDER COAT.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED		DRAWING NO.
MFG. APPR.		REV. B
APPROVED		D412-769-1
DE APPR.		SHEET 2 OF 7
DATE	08.06.25	TITLE
		SCALE
		AFT FACING SEAT ASSY, LH NTS
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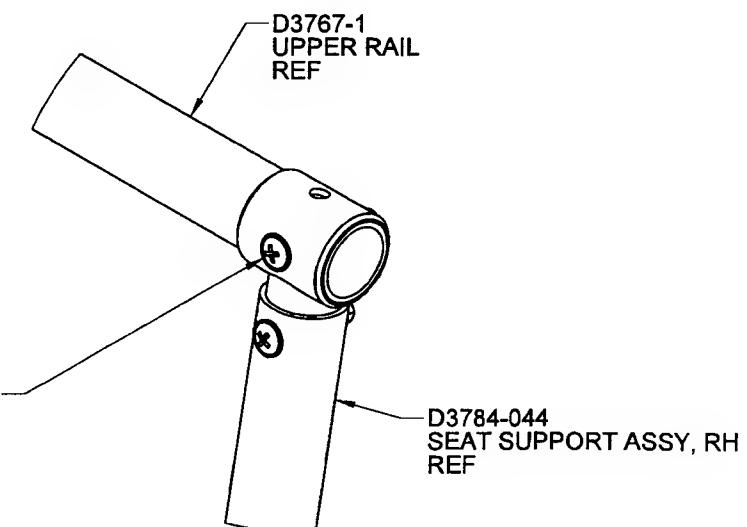
8 7 6 5 4 3 2 1

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DETAIL A D2-2
UPPER RAIL TO BACK LEG ATTACHMENT
2 PL



DETAIL B C1-2
SEAT SUPPORT END ATTACHMENT
5 PL

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07.09.11

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NO. 40822

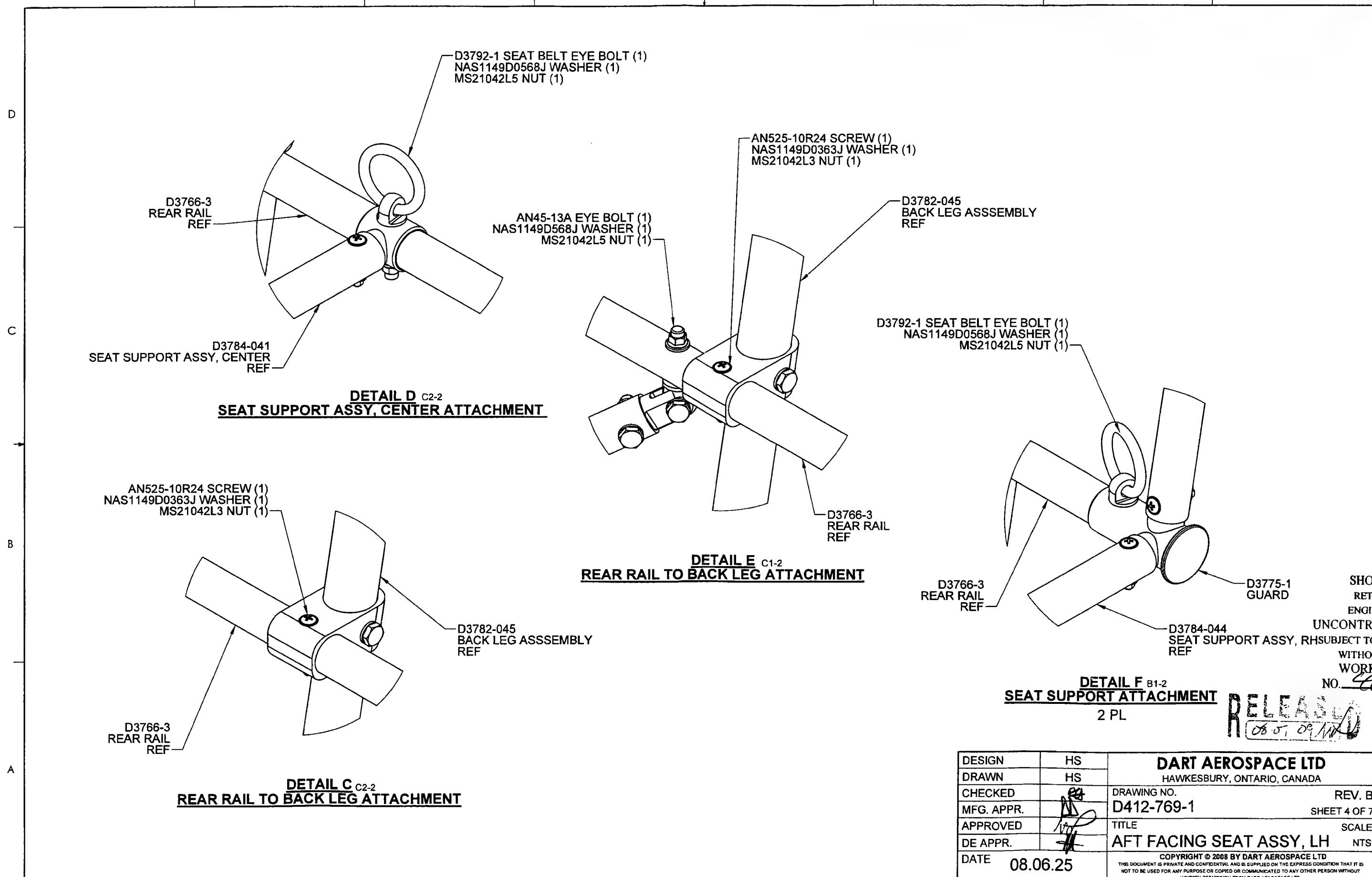
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DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	DRAWING NO.	
MFG. APPR.	MD	D412-769-1	REV. B
APPROVED	MM	SHEET 3 OF 7	
DE APPR.	MM	TITLE	
DATE	08.06.25	AFT FACING SEAT ASSY, LH	
NTS			

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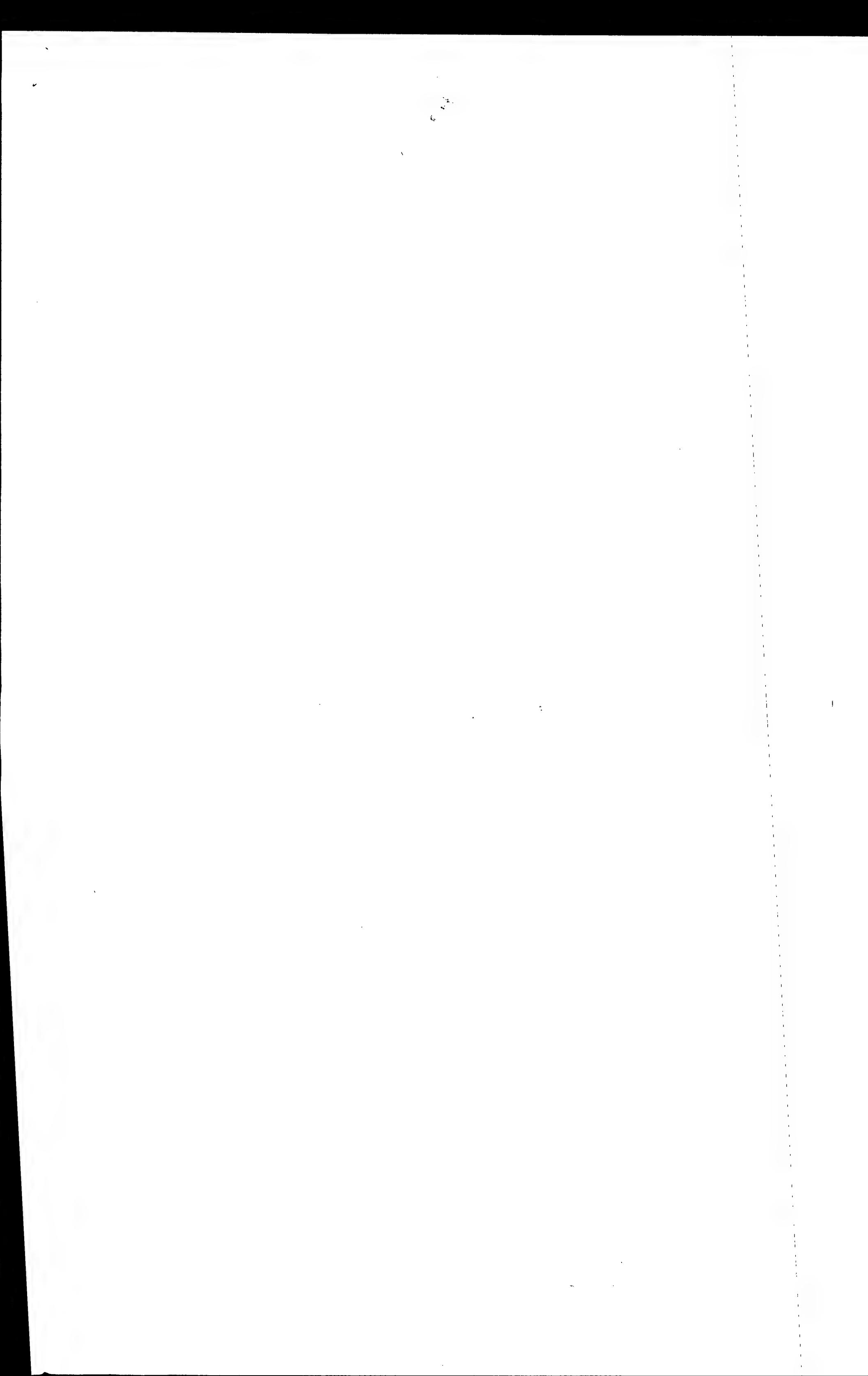
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8 7 6 5 4 3 2 1



DESIGN	HS	DART AEROSPACE LTD
DRAWN	HS	HAWKSBUCK, ONTARIO, CANADA
CHECKED	84	DRAWING NO.
MFG. APPR.	84	D412-769-1
APPROVED	84	REV. B
DE APPR.	84	SHEET 4 OF 7
DATE	08.06.25	TITLE
		SCALE
		NTS
		AFT FACING SEAT ASSY, LH
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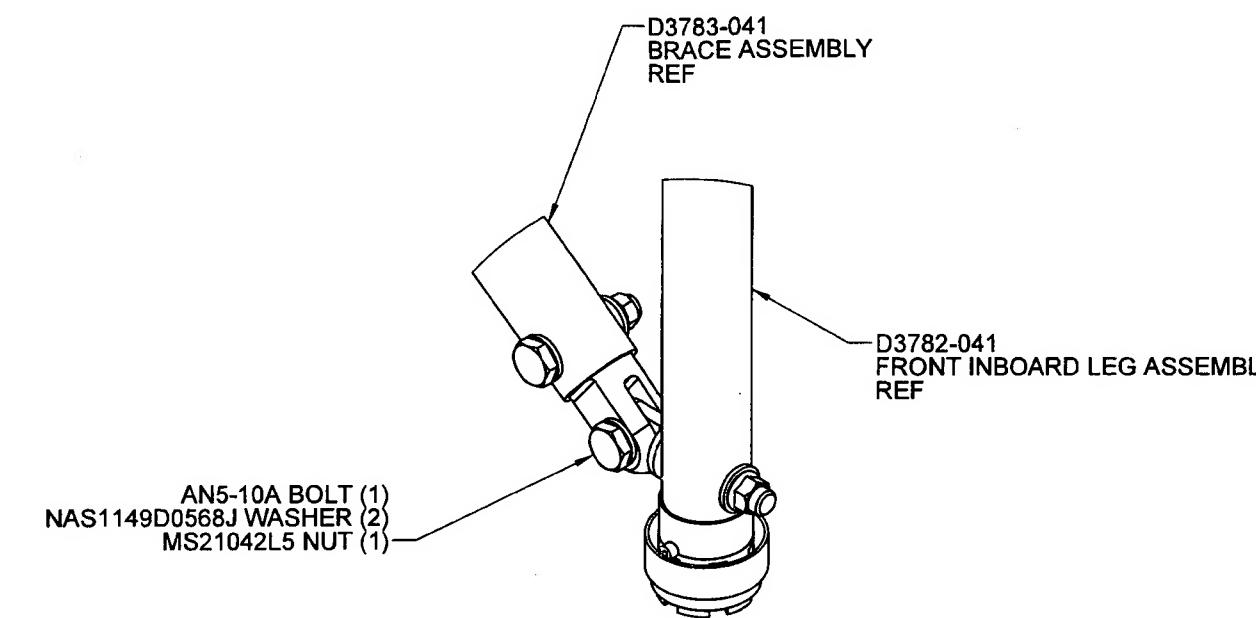
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DETAIL G_{B2-2}
BRACE ATTACHMENT

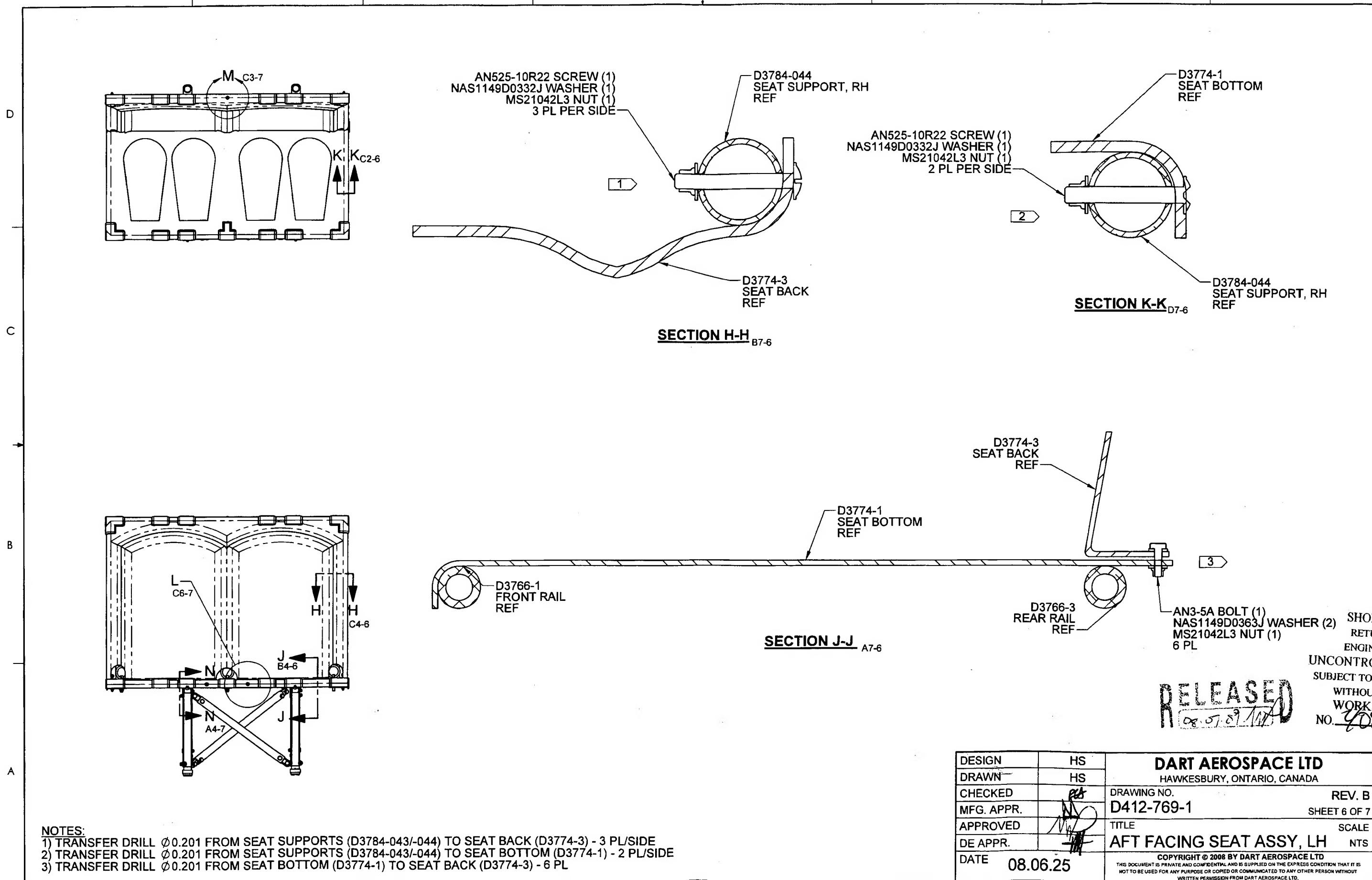
6 PL

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08.07.09 M
NO. 40822

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AS</i>	D412-769-1	SHEET 5 OF 7
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	AFT FACING SEAT ASSY, LH	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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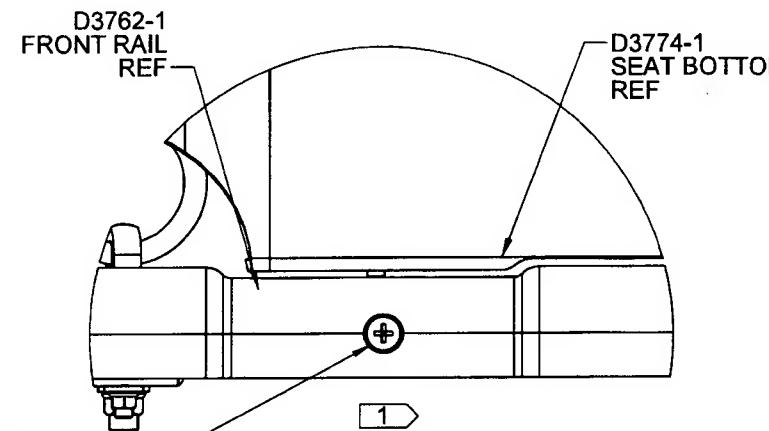
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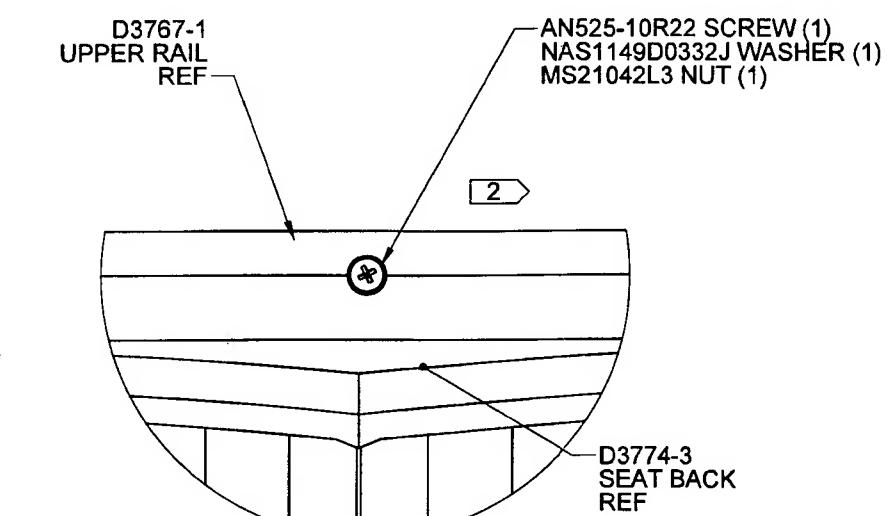
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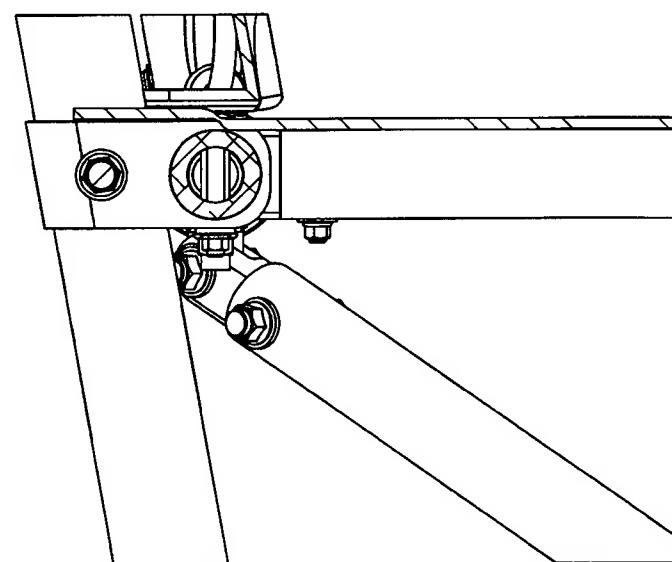
8 7 6 5 4 3 2 1



DETAIL L A7-6
SEAT BOTTOM ATTACH - FRONT DETAIL
2 PL



DETAIL M D7-6
SEAT BACK ATTACH - TOP DETAIL



SECTION N-N A8-6
FRONT LEG AND LONGITUDINAL ANGLE ATTACHMENT
2 PL

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DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PF	DRAWING NO.	
MFG. APPR.		D412-769-1	
APPROVED	M	REV. B	
DE APPR.		SHEET 7 OF 7	
DATE	08.06.25	TITLE	
		AFT FACING SEAT ASSY, LH	
		NTS	

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NOTES:
1) TRANSFER DRILL Ø 0.201 FROM FRONT RAIL (D3766-1) TO SEAT BOTTOM (D3774-1) - 2 PL
2) TRANSFER DRILL Ø 0.201 FROM UPPER RAIL (D3767-1) TO SEAT BACK (D3774-3) - 1 PL

8 7 6 5 4 3 2 1

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